

Work Order ID 164282

Monday, July 17, 2017 9:19:46 AM

164282

Page 1

Item ID: D3676-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bubble Window, LH

Start Date: 7/21/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/4/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 17 2017

Tooling:

Date:

Run Start

NR1QC: 3-89

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3676

Rev D

110

0.00

110

Purchasing

THERMOFORMING MACHINE

Memo

0.00

Purchasing

ISSUE P/O: 37108
SUPPLIER: PLASTECH

MANUFACTURE D3676-1 AS PER DWG

C OF C IS REQUIRED

2 JUL 19 2017DAS
13
9-89

140

0.00

140

Packaging

Receive & Inspect for Damage & Mat'l Certs
HAND FINISHING THERMOFORMING

Memo

0.00

Packaging

2x SPT-8-30
LH 17/9/06

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____									

Work Order ID 164282

Monday, July 17, 2017 9:19:46 AM

164282

Page 2

Item ID: D3676-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bubble Window, LH

Start Date: 7/21/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/4/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC6- All purchased or subcontracted products	0.00							
150									
QC	Memo	0.00				2			17-08-30
Quality Control									
170	Identify as per dwg & Stock Location: FG204	0.00							
170									
Packaging	Memo	0.00							DAS 07 9-89
Packaging									17/09/27
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							17/9/27
Quality Control									

DAS
21
9-89

SEP 27 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Picklist Print

Monday, July 17, 2017 9:19:50 AM

Page 1

Work Order ID: 164282

164282

Parent Item: D3676-1

D3676-1

Parent Item Name: Bubble Window, LH

Start Date: 7/21/2017

Required Date: 8/4/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev A New Product 01/24/2008 DL Verified:JLM
IPP Rev B Change Mat. to .236"" 08/29/2008 DL IPP Rev C
Added D3676-2 12/03/01 DL IPP Rev. D Udate dwg
add 20" dim to apex. 13/012/05 IPP Rev.E Now outside process DP
Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3676-1P		Purchased	No			110	Each	0.0000	1	2			
D3676-1P									**				
Bubble Window, LH													

2x SP17-8-30.

17.07.17

MacrLics .236

Batch: _____ qty per kit 1/403F

DQA: _____ Date: _____

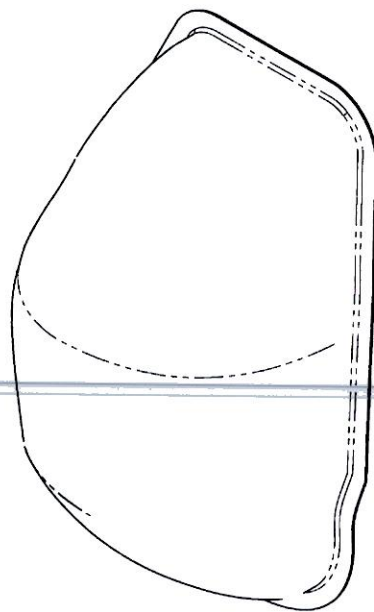
WORK ORDER NON-CONFORMANCE / UPDATE



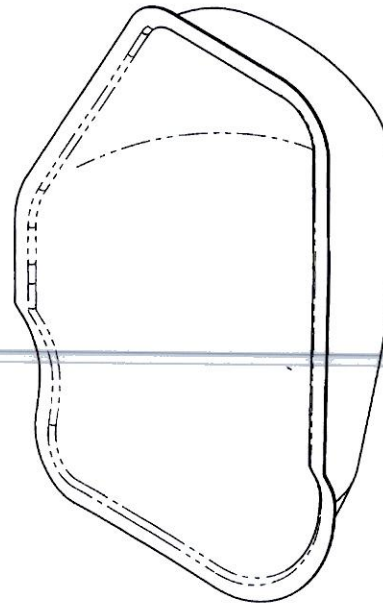
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
					Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
☐ OTHER : _____						



D3676-1 FULL HEIGHT BUBBLE WINDOW (LH)



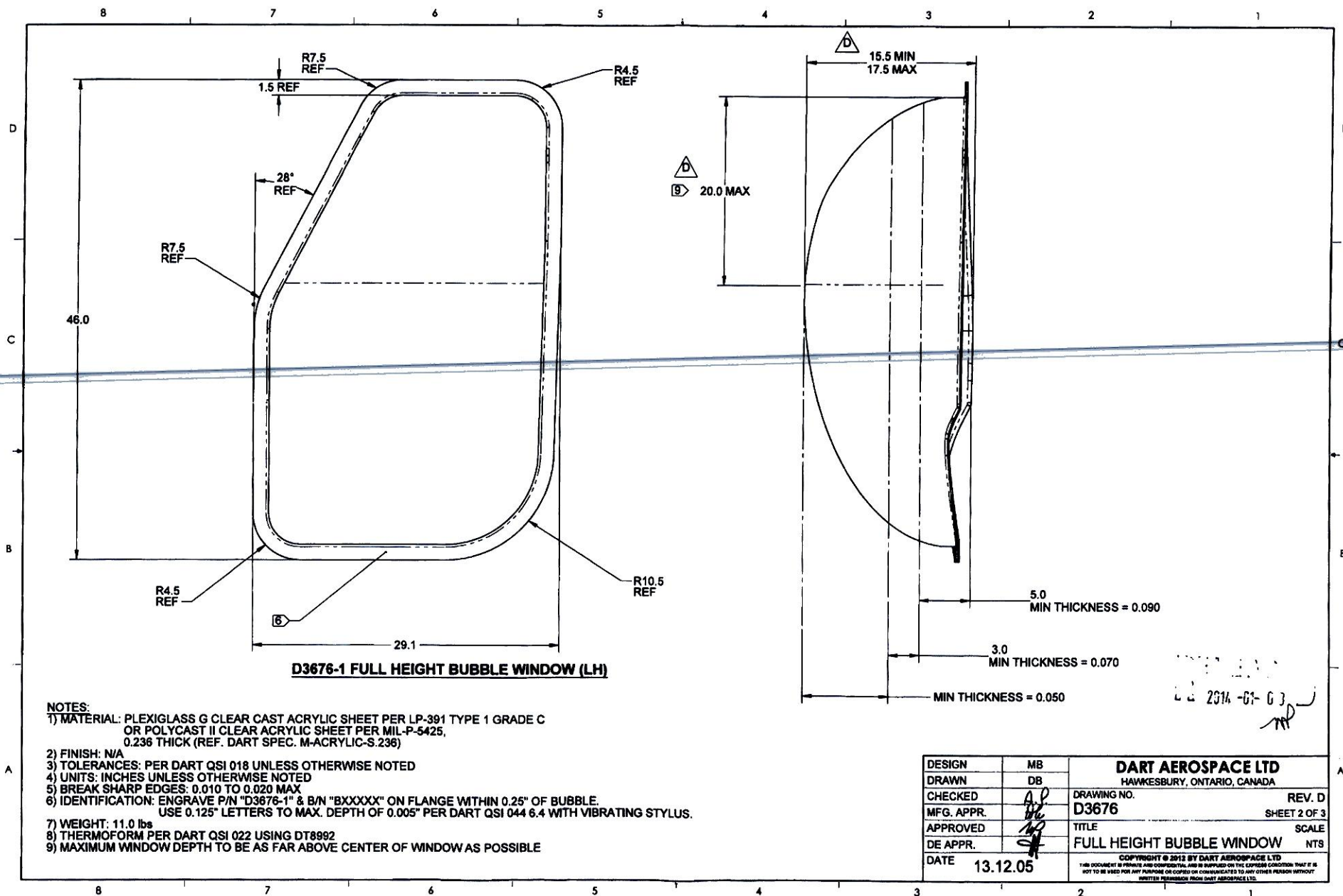
D3676-2 FULL HEIGHT BUBBLE WINDOW (RH)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 164282 MJS
1207-17

13.12.05
13.12.05
MB

D	UPDATE TOLERANCE ON DEPTH, ADD 20.0 MAX. VERTICAL DIMENSION (SH 2 & 3), NEW VIEW LAYOUTS ON SH 1 & 2	DB	13.12.05
C	ADDED D3676-2 FULL HEIGHT BUBBLE WINDOW (RH), REMOVED NOTES ON SHEET 1, REFORMAT NOTES 6 & 8 ON SHEET 2, D3676-1 WAS "412 BUBBLE WINDOW" NOW "FULL HEIGHT BUBBLE WINDOW (LH)".	AP	12.03.01
B	REVISED TOLERANCE ON MINIMUM THICKNESSES (ZN A8/B8-2), REASON: PRODUCTION FACILITY.	MB	08.10.27
A	NEW ISSUE	MB	08.02.29
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	MB	D3676	SHEET 1 OF 3
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	FULL HEIGHT BUBBLE WINDOW	NTS
DATE	13.12.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DESIGN	MB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	AP	D3676	SHEET 2 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	FULL HEIGHT BUBBLE WINDOW	NTS
DATE	13.12.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37108**

Purchase Order Date 7/19/2017

PO Print Date 7/19/2017

Page Number 1 of 9

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUL 19 2017

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3676-1P MANUFACTURE AS PER DWG D3676 REV. D B164282	Bubble Window, LH	7/31/2017 Yes 7/31/2017		2.00 Each	\$300.00	\$600.00
Line Total:							\$600.00
2	D5034-2P MANUFACTURE AS PER DWG D5034 REV. A B164305	Bubble Window	7/31/2017 Yes 7/31/2017	FN	2.00 Each	\$300.00	\$600.00
Line Total:							\$600.00
3	D3136-043P MANUFACTURE AS PER DWG D3136 REV. F B164248	Window Assembly	7/31/2017 Yes 7/31/2017	FN	4.00 Each	\$100.00	\$400.00

Note:

7/19/2017



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Packing Slip

Shipment Number: 24077
Shipment Date: 08/25/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 2

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order

37108

Carrier Account #

CU103666

Sales Order

SO-019288

Ship Via

FREIGHTCOM INC. -

Incoterms

EX WORKS

Payment Method

PPD/CHG

Tracking Number**Item Number - Revision Description**

D3676-1 - Rev.: D

FULL HEIGHT BUBBLE WINDOW (LH)

AS PER DWG D3676 REV. D

HS Code: 3920.51.1000 - OTHER Country of Origin : CA

D4941-1L02 - Rev.: D

CABIN FLOOR PROTECTORS

HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D4941-2L02 - Rev.: D

CABIN FLOOR PROTECTORS

HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D4941-3L02 - Rev.: D

CABIN FLOOR PROTECTORS

HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D4941-4L02 - Rev.: D

CABIN FLOOR PROTECTORS

HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D3874-1L02 - Rev.: B

FLOOR PROTECTOR CO-PILOT BLACK

AS PER DWG D3874 REV. B

HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D3874-2L02 - Rev.: B

FLOOR PROTECTOR PILOT BLACK

AS PER DWG D3874 REV. B

HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D3774-1 - Rev.: B

SEAT BOTTOM

AS PER DWG D3774 REV. B

HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D3774-3 - Rev.: B

SEAT BACK

AS PER DWG D3774 REV. B

HS Code: 3920.61.1000 - OTHER Country of Origin : CA

**Quantity UOM
Shipped**

2 EA

2 EA

2 EA

2 EA

2 EA

4 EA

4 EA

2 EA

2 EA

SPN-8-30